: CROSSBOLT SPACER

: D2743

: N/A

: NIA

: 3/20/2006

: B

D2743 REV B

Date: User:

Monday, 3/13/2006 7:29:55 AM

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 26208

Estimate Number

: 10329

P.O. Number

Prsht Rev.

First Issue

Written By

Previous Run

This Issue

:N/A

: 3/13/2006

: 25838

: N/A

S.O. No. : N/A

Type

: MACHINED PARTS

Total:

Comment

Reformat: removed tumble and deburr step KJ/J

LM

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Tube .625 x.065W

1.0

M6061T6T0625W065

Comment: Qty.:

Material: 6061-T6 (WW-T-700/6)

Ø0.625 " x 0.065" wall

(M6061T6T0.625W.065)

M19051

56.0070 f(s)

Batch: M/00 45/

Each

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA202 and Dwg D2743

23 o

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHI



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHÉCK



30

4.0

QC8





230

Comment: SECOND CHECK PACKAGING 1

PACKAGING RESOURCE #1

5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_

BALLAY

Page 1

Form: rprocess

Dart	Ae	ros	pac	e Ltd
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	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-					
Part No	:	PAR #:	Fault Cate	gory:					
							d:	Date:	
NCR:		'	WORK ORD	ER NON-CONFORMA	ANCE (NCI	₹)			
DATE	STEP	Description of NC	Description of NC Corrective Action			on B Verification			Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	ign & Section C		Approval Chief Eng	QC Inspector
	-								

NOTE: Date & initial all entries

Date:

Monday, 3/13/2006 7:29:56 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 26208

Part Number: D2743

9

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-04-13

Dart	Aer	ospa	ce Ltd
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	-								
W /O:			WC	ORK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHA	NGE	By Date			Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
								_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	CTED	Description of NC	Description of NC Corrective Action Section B			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
						,			
	3								
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26208
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743 Rev: B		Page 1 of 1

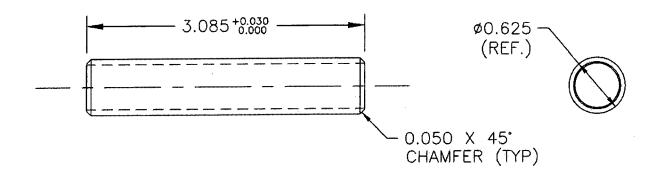
nspection Dw	g: D2/43 R	ev: B					age i oi i
	FIR	ST ARTICLE	INSPEC	TION CH	ECKLIST		
		X First A	rticle [Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
3.085	+0.030/-0.000	3.095	>				
Ø0.625	+/-0.010	1675	V				
0.050 x 45°	0.048 x 45°	1050×45°	<u> </u>				
0.065	+/-0.010	.065					
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easured by:	BA	Audited by:	5.6		Prototype App	roval:	N/A
Date:	06/04/10	Date:	4 ((/)		Date:	N/A
ev Date	Change				R	evised by	Approve
A 04 04 20	Now Icouc				l K	1/05 -4/16	- 1 '- T inj





DESIG	#	DRAWN BY	DART AEROSPACE BELLEVUE, WA	USA, INC.
CHECK	(ED	APPROVED	DRAWING NO.	REV. B
\mathcal{J}	#	1 KE	D2743	SHEET 1 OF 1
DATE	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		TITLE	SCALE
98.1	2.08		CROSS BOLT SPACER	1:1
 Α		98.04.16	NEW ISSUE	
В		98.12.08	3.085 WAS 3.060	

RELEASED PS



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

SURJECT TO AMENDMENT

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